

Work Order ID 135820

135820

August 20, 2015 2:33:37 PM

Order to ship Sept 3rd/15

Page 1

Item ID: D206-642-216 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH, High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)
 Start Date: 8/20/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/3/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: SLA Date: 20150820 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
100									
DC		0.00							
Doc. Control -USB or Paperwork	Memo Photocopy bluefile & type labels per PPP D206-642-216 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

B135825LH

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : ☐																					

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Item ID: D206-642-216

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Stop ***NS2***

Start Date: 8/20/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/3/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130					DAS				
Packaging	Memo	0.00			02				
Packaging	Identify and pack for shipping as per PPP D206-642-216 Location: FG083				9-89				
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ

SEP 03 2015

MF

15-8-3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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D206-642-216

Required Date: 9/3/2015

Required Qty: 1.00

Comments: IPP REV:A 11.11.17 PER IIN REVO DD VERF;EC IPP Rev:B
12.11.21 ECN12-679 DD verf:JLM IPP Rev:C 14.04.25
ECN14-520 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-251		Manufactured	No			110	Each	0.0000	1	1			DAS 02 9-89
D206-642-251 Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH 135825													
D206-651-041		Manufactured	No			110	Each	10.0000	1	1			DAS 02 9-89
D206-651-041 206 A/B GHW 1													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		1							
				79558		1							
				PKG012		9							
				112977		1							
				114414		8							
AN4C5A		Purchased	No			110	Each	27.0000	1	1			DAS 02 9-89
AN4C5A Bolt 1													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP001		6							
				131677		6							
				ST345		20							
				m132857		20							
				ST346		1							
				131677		1							

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Work Order ID: 135820

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Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0463R

Purchased No

110 Each

241.0000

1

DAS

DAS

NAS1149C0463R

Washer

DAS
6
9-89

**

27

02

9-89

9-89

Location

Loc Qty

Loc Code

FP001

77

m127306

77

ST271

164

m128401

164

110

Each

13.0000

1

**

D3413-1

Manufactured No

D3413-1

O-Ring

DAS
6
9-89

Location

Loc Qty

Loc Code

st530

13

125157

3

129085

1

132500

2

133922

7

110

Each

108.0000

16

16

**

DAS

DAS

27

02

9-89

9-89

AUG 26 2015

D2652

Manufactured No

D2652

Bushing

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

45

31985

45

ST009

21

129993

17

134494

4

ST012a

42

123711

32

124422

2

8905

8

B1355B

16

DAS

DAS

27

02

9-89

9-89

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Work Order ID: 135820

135820

Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH, High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

D2665-2
D2665-2

Saddle, RH, Fwd, Aft, Out

DAS
8
9-89

Manufactured No

110 Each

4.0000

2 2

**

DAS

DAS

27

02

9-89

9-89

Location

Loc Qty

Loc Code

ST403

4

131091

1

131615

2

135239

1

D2666-2
D2666-2

Saddle, RH, Fwd, Aft, In

DAS
8
9-89

Manufactured No

110 Each

6.0000

2 2

**

DAS

DAS

27

02

9-89

9-89

Location

Loc Qty

Loc Code

ST402

6

113167

1

121591

4

135237

1

D2712
D2712

Set Screw

DAS
8
9-89

Manufactured No

110 Each

155.0000

10 10

**

DAS

DAS

27

02

AUG 26 2015

9-89

Location

Loc Qty

Loc Code

FG

55

29962

55

ST009

10

89929

10

ST012a

90

130024

90

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Work Order ID: 135820

135820

Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

D2884

Manufactured No

110

Each

16.0000

2 2

D2884

Saddle Spacer

**

DAS

DAS

27

02

9-89

9-89

Location

Loc Qty

Loc Code

FG

10

29453

10

ST013

6

113032

6

D2885

Manufactured No

110

Each

24.0000

2 2

D2885

Saddle Spacer

**

DAS

DAS

27

02

9-89

9-89

Location

Loc Qty

Loc Code

FG

10

29199

10

ST013

14

110795

1

121615

13

AN3-41A

Purchased No

110

Each

586.0000

8 8

AN3-41A

Bolt

**

DAS

DAS

27

02

9-89

9-89

Location

Loc Qty

Loc Code

FG

20

122416

20

ST338a

566

123355

566

DAS
6
9-89

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Work Order ID: 135820

135820

Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-6A

Purchased

No

110

Each

709.0000

12

12

AN4-6A

BOLT

DAS
8
9-89

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

CA

143

M128403

43

M130851

100

ST345

566

M128403

8

~~M131153~~

558

AN5-7A

Purchased

No

110

Each

4,351.000

4

4

AN5-7A

Bolt

DAS
8
9-89

**

DAS
27
9-89

68-6
20
SVD

Location

Loc Qty

Loc Code

ST299A

4230

M119017

2400

M123355

1510

M123532

20

m126010

300

ST338

121

m126105

121

AN5-11A

Purchased

No

110

Each

30.0000

4

4

AN5-11A

BOLT

DAS
8
9-89

**

DAS
27
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST299A

28

M126105

1

M132189

27

ST338

2

M132551

2

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Work Order ID: 135820

135820

Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

AN6-44A	Purchased	No	110	Each	186.0000	2	2		
AN6-44A						**		DAS 27	DAS 02
Bolt								9-89	9-89

DAS
6
9-89

Location	Loc Qty	Loc Code
ST286A	149	
123265	149	
ST333	37	
123265	37	

NAS1149D0363J

Purchased

No

110

Each

1,021.000

8

NAS1149D0363J

Washer

**

DAS	DAS
27	02
9-89	9-89

DAS
6
9-89

Location	Loc Qty	Loc Code
CA	246	
m130799	246	
GA	323	
m130799	323	
ST269	452	
m126319	7	
m131618	1	
m132317	108	
m132677	336	

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Work Order ID: 135820

135820

Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

2,760.000

24

24

NAS1149D0463J

WASHER

**

DAS
27
9-89

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M132677

1000

ST269

1719

M127904

20

M129682

86

M130799

371

M132035

1117

M132317

125

24

NAS1149D0563J

Purchased

No

110

Each

1,045.000

8

8

NAS1149D0563J

Washer

**

DAS
27
9-89

DAS
02
9-89

AUG 26 2015

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

817

m130799

63

m132035

55

m132256

99

m132677

600

8

ST269

156

m128257

156

ST271

19

m131026

19

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Work Order ID: 135820

135820

Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0663J

Purchased

No

110

Each

1,227.000

4

4

NAS1149D0663J

Washer

DAS
02
27 9-89
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST260

227

M131618

227

ST260a

933

M132256

933

ST269

67

M126334

67

MS21042L3

Purchased

No

110

Each

1,353.000

8

8

MS21042L3

Nut

DAS
02
27 9-89
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

264

M131317

264

ST305

696

116549

12

126333

49

M128754

2

M132123

17

M132382

2

M132883

114

M132930

500

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8

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Work Order ID: 135820

135820

Parent Item: D206-642-216

D206-642-216

Parent Item Name: Skidtube RH,High Gear, Run-on Landing (2.5" Bolt Spacing on Aft Saddle)

Start Date: 8/20/2015

Required Date: 9/3/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

2,576.000

12 12

MS21042L4

Locknut

**

DAS
27
9-89

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

124

m127813

124

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

2280

m128300

8

m128798

12

m130388

7

m130922

97

m131618

12

m132123

56

m132382

2088

MS21042L6

Purchased

No

110

Each

244.0000

2 2

MS21042L6

Nut

**

DAS
27
9-89

DAS
02
9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

ST260a

26

m132262

26

ST273A

200

m131624

200

ST305

1

m129909

1

t260a

17

m131317

17

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4.4 206A/B HIGH GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY -215	QTY -216	QTY -217	QTY -218	QTY -251	QTY -249	PART NUMBER	DESCRIPTION
	X						D206-642-215	SKIDTUBE INSTALLATION, LH
		X					D206-642-216	SKIDTUBE INSTALLATION, RH
			X				D206-642-217	SKIDTUBE INSTALLATION, THRU BOLT, LH
				X			D206-642-218	SKIDTUBE INSTALLATION, THRU BOLT, RH
	1	1	1	1	X		D206-642-251	SKIDTUBE
						X	D206-642-249	RUN-ON WEARPLATE KIT
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ⁽¹⁾
1					1		D3804-043	SKIDTUBE ASSEMBLY
2A					8		D2651-1	* PLUG ⁽¹⁾
2B					8		D2651-3	* O-RING ⁽¹⁾
3					1		D2646	* AFT CAP ⁽¹⁾
4					2		MS27039-1-08	* SCREW ⁽¹⁾
5					2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
5	1	1	1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1	1	1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1	1					D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT, RH
9	1	1					D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3-41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4			AN5-7A	BOLT
14	4	4	4	4			AN5-11A	BOLT
14A			2	2			AN5-32A	* BOLT ⁽²⁾
14B			2	2			MS21042-5	* NUT (OR MS21042L5) ⁽²⁾
15	8	8	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12			AN4-8A	BOLT
17	24	24	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12			MS21042-4	NUT (OR MS21042L4)
20A					1	1	D3805-043	FWD WEARPLATE ASSY
22A					1	1	D3805-047	AFT WEARPLATE ASSY
26A					7	7	AN3-36A	BOLT
26B					7	7	NAS1149C0332R	WASHER (OR AN960C10L)
26C					7	7	MS21042-3	NUT (OR MS21042L3)
26D					14	14	D3873-1	BUSHING
27						2	D2649	SPACER
28	2	2	2	2			AN6-44A	BOLT
29A	2	2	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1	1	1			AN4C5A	BOLT
35	1	1	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1			D3413-1	RING
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D3804-043 ASSEMBLY ABOVE

⁽²⁾ NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS